

Date: Tuesday, 17/02/2009 11:09:08 AM
 User: Melanie Fauteux

Process Sheet

Customer :	CC-DAR01 Dart Aerospace Ltd.	Drawing Name :	REWORK
Job Number :	45839		
Estimate Number :	10804		
P.O. Number :		Part Number :	D206628012
This Issue :	17/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	REWORK
First Issue :	17/02/2009	Project Number :	
Previous Run :	00015	Drawing Revision :	
		Material :	
Written By :		Due Date :	17/02/2009
Checked & Approved By :	MF 09-02-17		
Comment :			

Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

D206-628-012 B 39911 X 1 WAS USED AND TESTED FOR HAI SHOW
 REPLACE PARTS THAT WERE SCRAPPED
 PUT BACK IN STOCK UNDER NEW BATCH NUMBER

2.0	D206628012	Heli-Access-Step RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Heli-Access-Step RH

b 39911

MF 09-02-18

3.0	D2732030	Rubber Cushion
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Rubber Cushion

38509

JS 09/02/17 (X)

4.0	AN413A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Bolt

M107959

110865

JS 09/02/17 (X)

5.0	AN414A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Bolt

M107534

JS 09/02/17 (X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 11:09:08 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 45839

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27313

Mounting Lug



B37335



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Lug

MP old kit

7.0

D27317

Mounting Lug



B37336



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Mounting Lug

N/A old kit

8.0

D3394041

Lug Assembly



B37345



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Lug Assembly

N/A old kit

9.0

D3394043

Lug Assembly



B34834



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Lug Assembly

N/A old kit

10.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Bolt

M110389



JS 09/02/17 (X)

11.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Washer

M110523



JS 09/02/17 (X)

12.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)
Nut

M109282



JS 09/02/17 (X)

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

chgo3



20902.19 (1)

ENSURE LABELS AND PAPERWORK ARE IDENTIFIED UNDER NEW BATCH NUMBER

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 11:09:08 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 45839

Part Number: D206628012

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



09/02/20
MF 09-02-18

Packaging per F
9/2/18

(1x) 50

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON. CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D206-628-012	CHG	CHG003
DESC	Heli-Access-Step RH	STC	SH98-14
LOT	B39911	STC	SA00500SE
MODEL	Bell 206A/B	STC	
MADE IN CANADA			
D2729-1			

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
2	2			4	4	D2731-3	MOUNTING LUG
2	2	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
2	2			4	4	D3394-041	MOUNTING LUG
2	2			4	4	*D3394-1	*MOUNTING LUG
4	4			8	8	*MS35489-93	*GROMMET
2	2	4	4			D3394-043	MOUNTING LUG
2	2	4	4			*D3394-3	*MOUNTING LUG
4	4	8	8			*MS35489-93	*GROMMET
4	4			4	4	AN4-13A	BOLT
4	4	4	4	4	4	AN4-14A	BOLT
4	4	8	8	4	4	AN4-15A	BOLT
12	12	12	12	12	12	AN960JD416	WASHER
12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

45839

Date: Tuesday, 17/02/2009 10:45:39 AM

User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 39911	Customer	: Dart Helicopters Services
Estimate Number	: 11115	DWG Name	: 206 A/B STEP ASSEMBLY RH
Purchase Order #	:	Part Number	: D206628012
Complete Date	: 31/07/2008 4:39:59	DWG Number	: N/A
Rev.	: N/A		

DUE DATE	ORDERED	DELIVERED
05/07/2008	4	4

3.0 D2721041-206B Step Assembly	SUB-Component/Sub-job
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DATE	EMPLOYEE	TYPE	Qty			
31/07/2008	FAUT01: Fauteux, Melanie		4.000		\$2974.38	39911A
Subtotal:			CTD: 4		\$2974.38	

4.0 D2732-Rubber Extrusion	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
31/07/2008	FAUT01: Fauteux, Melanie	D2732	8.000		\$31.84	Lot # 37632 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$31.84	

5.0 AN413A-Bolt	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	AN413A	16.000		\$4.51	Lot # 107959 Qty. 6 Lot # 108700 Qty. 10
Subtotal:			QTD: 0	CTD: 16	\$4.51	

6.0 AN414A-Bolt	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	AN414A	16.000		\$4.34	Lot # 107534 Qty. 16
Subtotal:			QTD: 0	CTD: 16	\$4.34	

7.0 D27313-Mounting Lug	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	D27313	8.000		\$51.23	Lot # 37335 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$51.23	

8.0 D27317-Mounting Lug	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	D27317	8.000		\$117.32	Lot # 37336 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$117.32	

9.0 D3394041-Lug Assembly	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	D3394041	8.000		\$151.97	Lot # 37345 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$151.97	

10.0 D3394043-Lug Assembly	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	D3394043	8.000		\$174.06	Lot # 34834 Qty. 8
Subtotal:			QTD: 0	CTD: 8	\$174.06	

11.0 AN415A-Bolt	INVENTORY ITEM
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DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	AN415A	12.000		\$2.41	Lot # 108077 Qty. 12
31/07/2008	FAUT01: Fauteux, Melanie	AN415A	4.000		\$0.80	Lot # 108077 Qty. 4
Subtotal:			QTD: 0	CTD: 16	\$3.21	

REFERENCE ONLY

Date: Tuesday, 17/02/2009 10:45:39 AM
 User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 39911	Customer	: Dart Helicopters Services
Estimate Number	: 11115	DWG Name	: 206 A/B STEP ASSEMBLY RH
Purchase Order #	:	Part Number	: D206628012
Complete Date	: 31/07/2008 4:39:59	DWG Number	: N/A
		Rev.	: N/A

12.0 AN960JD416-Washer INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	AN960JD416	48.000		\$1.42	Lot # 107939 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$1.42

13.0 MS21042L4-Nut INVENTORY ITEM

DATE	EMPLOYEE	TYPE	Qty		COST	
29/07/2008	DESJ02: Desjardins, Line	MS21042L4	48.000		\$8.19	Lot # 107478 Qty. 48
Subtotal:		QTD:	0	CTD:	48	\$8.19

		TIME	COST	
	Machine Time:	0.00	\$0.00	
	Labor:	0.00	\$0.00	
	Sub-contract (external Op.):		\$0.00	
	INVENTORY ITEM:		\$548.09	
	SUB-COMPONENT (SUB-JOB):		\$2974.38	
Total:			\$3522.47	

COST PER UNIT: \$880.61

REFERENCE ONLY

Date: Tuesday, 17/02/2009 10:02:05 AM

User: Melanie Fauteux

Bill of Manufacturing

B 45839

Part Number : D206628012
 Drawing Name : 206 A/B STEP ASSEMBLY RH

Revision : N/A
 Default Qty. : 1

Seq #	Item	Description	Qty	U/M	Unit Cost	BOM Cost
1	DC	DOCUMENT CONTROL	0.00	Hours	26.00	0.00
2	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
3	D2721042	206B STEP ASSY, RH	1.00	Each	0.00	0.00
▪ 1	D2622120C	Qty Part# Description Batch:	1.00	Each	25.21	25.21
▪ 2	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
▪ 3	D2734	206 Step Endplate	2.00	Each	0.89	1.78
▪ 4	D34611	206 Step Lug	1.00	Each	71.11	71.11
▪ 5	D34613	Pick:	1.00	Each	0.00	0.00
▪ 6	D34615	Pick:	1.00	Each	15.03	15.03
▪ 7	D34617	Pick:	1.00	Each	23.73	23.73
▪ 8	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
▪ 9	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
▪ 10	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
▪ 11	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	90.00	0.00
▪ 12	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	26.00	0.00
▪ 13	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	0.00	Hours	90.00	0.00
▪ 14	QC9	VISUAL WELDING INSPECTION	0.00	Hours	26.00	0.00
▪ 15	QC5	INSPECT WORK TO CURRENT STEP	0.00	Hours	43.00	0.00
▪ 16	HAND FINISHING1	HAND FINISHING RESOURCE #1	0.00	Hours	90.00	0.00
▪ 17	POWDER COATING	POWDER COATING	0.00	Hours	90.00	0.00
▪ 18	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	26.00	0.00
▪ 19	HAND FINISHING1	Wing Walk as per Dwg D2721 and QSI 00 5 4.4	0.00	Hours	90.00	0.00
▪ 20	QC3	INSPECT POWDER COAT/CHEMICAL	0.00	Hours	26.00	0.00
▪ 21	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
▪ 22	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
4	D2732030	Rubber Cushion	8.00	Each	0.75	6.00
5	AN413A	Bolt	4.00	Each	0.28	1.13
6	AN414A	Bolt	4.00	Each	0.26	1.06
7	D27313	Pick:	2.00	Each	4.76	9.52
8	D27317	Pick:	2.00	Each	4.82	9.64
9	D3394041	Pick:	2.00	Each	0.00	0.00
10	D3394043	Pick:	2.00	Each	0.00	0.00
11	AN415A	Pick:	4.00	Each	0.19	0.79
12	AN960JD416	Pick:	12.00	Each	0.03	0.36
13	MS21042L4	Pick:	12.00	Each	0.08	1.01
14	QC4	INSPECT 100% KITS FOR COMPLETENESS	0.00	Hours	26.00	0.00
15	PACKAGING 1	PACKAGING RESOURCE #1	0.00	Hours	57.00	0.00
16	QC21	FINAL INSPECTION/W/O RELEASE	0.00	Hours	0.00	0.00
Total BOM Cost						166.39

DC Paperwork / Labels

JUD 09.02.17